

March 09, 2016 10:26:00 AM Bearpaw weaplates.

Page 1

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Work Order ID 142436

March 09, 2016 10:26:00 AM

142436

Page 2

Item ID: D4379-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Cup
 Start Date: 3/21/2016 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 3/31/2016 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03		B.A 16/03/13		80	0		DAS 08 9-29
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION: WA002	0.00 0.01				80			DAS 6 9-29 MAR 16 2016
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.13							16/1/15 J

MW MAR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

Picklist Print

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Page 1

Work Order ID: 142436

142436

Parent Item: D4379-1

D4379-1

Parent Item Name: Wearplate Cup

Start Date: 3/21/2016

Required Date: 3/31/2016

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP REV:A NEW ISSUE 11-04-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No				f	25.5390		12.63158			DAS 40 9-89
M304RO 750									**			16/03/12	
304 SS Roundbar .750													

Location

Loc Qty

Loc Code

MAT029

25.539

M128005

0.247

M128496

1.842

M133587

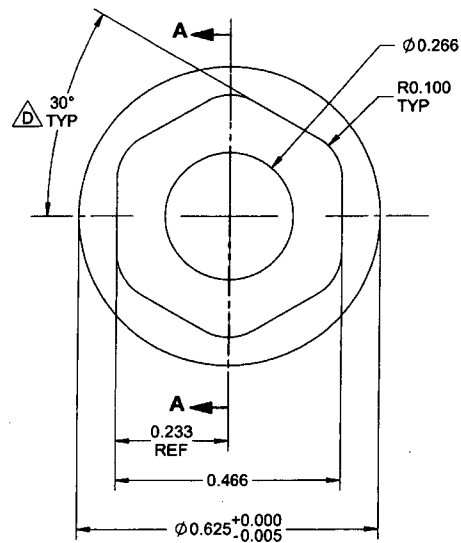
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M134158

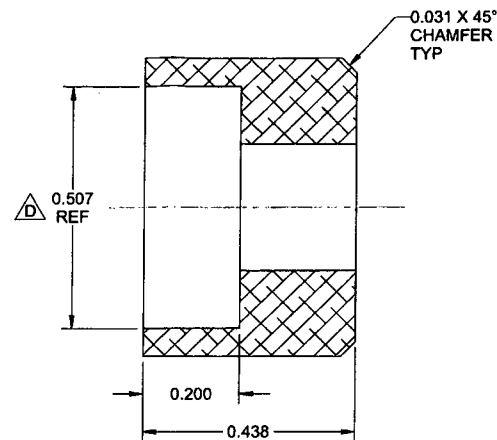
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~~1,335~~ 1,842
3,452

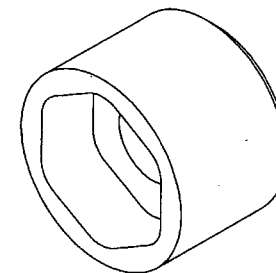
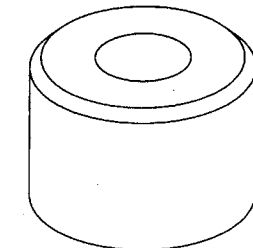
4,788



D4379-1 WEARPLATE CUP



SECTION A-A



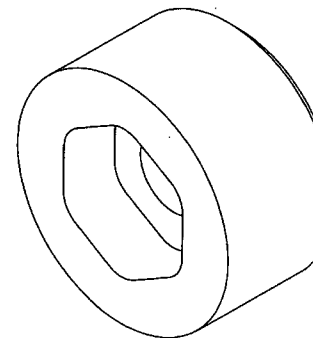
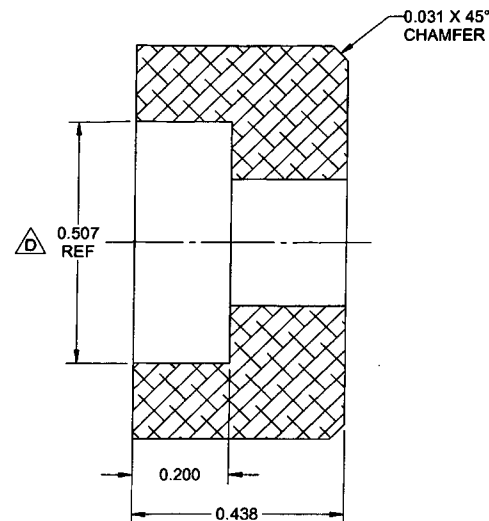
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

RELEASED
2016-02-23
EEN 16-529

D	ADDED -7 SEE CIR 15-44. 30° ANGLE DIMENSION ADDED TO TO ALL PARTS 0.507 DIMENSION CHANGED TO REF.	AJS	15.12.17
C	ADD D4379-5 WEARPLATE CUP	DB	14.03.19
B	ADD D4379-3 WEARPLATE CUP	AP	12.07.04
A	NEW ISSUE	AJS	11.03.22
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4379	SHEET 1 OF 4
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DE APPR.	DS	WEARPLATE CUP	NTS
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DRAWN	AJS		SHEET 2 OF 2
CHECKED	ML		SCALE
MFG. APPR.	JLM		NTS
APPROVED	WM		
DE APPR.	DS		
DATE	15.12.17		

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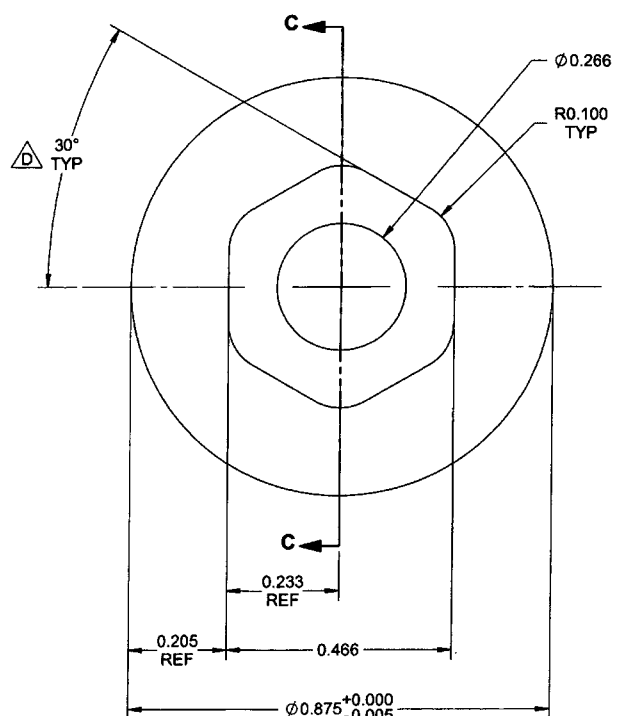
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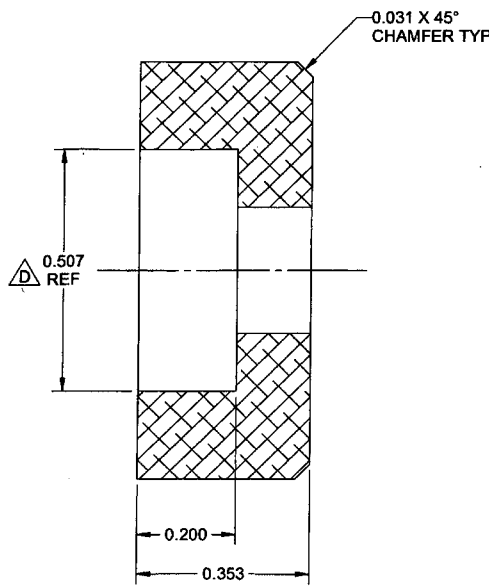
C

B

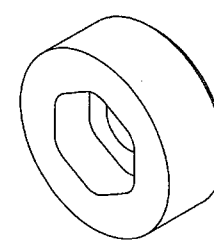
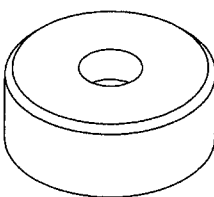
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D4379-5 WEARPLATE CUP



SECTION C-C



D

C

B

A

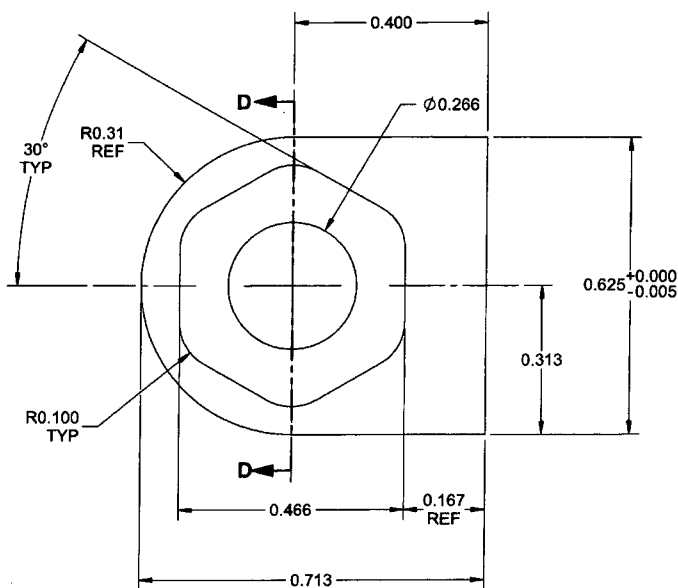
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs

RELEASED
2016-02-23

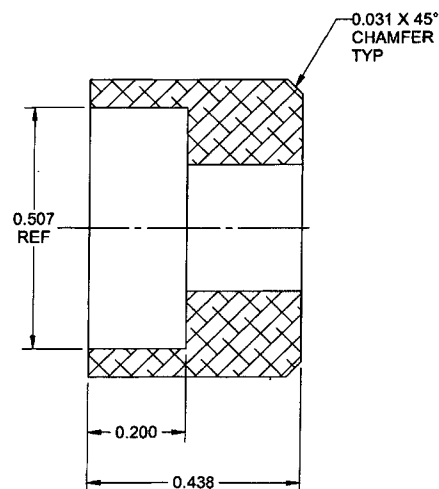
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4379	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
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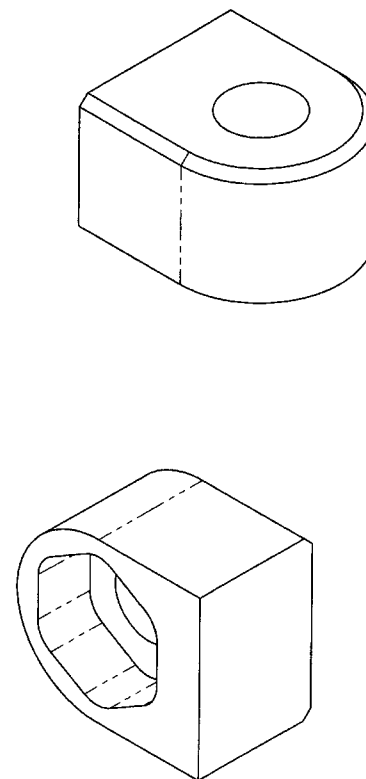
8 7 6 5 4 3 2 1



D4379-7 WEARPLATE CUP



SECTION D-D



- NOTES:**
- 1) MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE
PER ASTM A276 OR ASTM A240
REF. DART SPEC M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.04 lbs

RELEASED
2016-02-23

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DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4379	SHEET 4 OF 4
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